

NOTES:

- FLARE PER SAE J533, AFTER ANODIZING AND NUT/SLEEVE INSTALLATION.
- WELD PER EPS-1003 CLASS C
- EJECTOR TO BE SET AS SHOWN FOR PROPER FLOW/ACOUSTICAL CHARACTERISTICS.
- 19 TEE TO BE LOCATED WITHIN .010 OF TUBE CENTERLINE. ALIGNMENT BETWEEN -19 TEE AND -12 TUBE CENTERLINE TO BE ±0.5°.
- FINISH: ANODIZE THE WELDED ASSEMBLY PER MIL-A-8625 TYPE 2 CLASS 2. COLOR: OPTIONAL
- BORES & THREAD MUST BE CONCENTRIC WITHIN 0.001
- CYLINDRICAL SHAFT & THREAD MUST BE CONCENTRIC WITHIN 0.001

SHEET	REV	ECO	DATE	DESCRIPTION	APR	CHK
	A		12/31/85	ADDED NOTES 5 & 6. ADDED VIEW A,B,C. -14 STAINLESS WAS STEEL. -12 TUBE WAS T=0.075	NS	
	B		02/18/86	ADDED -15 TEE. OBSOLETE -13 TEE. VIEW B DIM 0.020 WAS 0.10	NS	
	C		05/01/86	DELETED NOTE 5. ADDED MATERIAL CALLOUT FOR -15	NS	
	D		02/20/90	-11 TUBE LENGTH WAS 1.48. OBSOLETE -13 TEE REMOVED. HOLE DIA., -12 TUBE WAS 0.47. AN315-5 WAS MS21042L-3	BR	
1-4	E		10/21/91	-16 PIN WAS -14 PIN. -17 TEE WAS -15 TEE. ADDED MS21042L-3 NUT, AN960PDIOL WASHER. ADDED SHEET 4.	REB	
1-5	F		01/20/92	ADDED SHEET 5. -18 PIN WAS -16 PIN. -17 TEE WAS -15 TEE. AN315-4 WAS AN315-5. DELETED NOTE 6. -12 TUBE WAS 5052-0 ALT. 6061-T6	BR	
1, 5	G		10/03/94	-18 PIN DIM 1.600 WAS 1.540, 0.554 WAS .454. 1/4-28-X-0.600 COMPLETE THREAD WAS 1/4-28 THD. 0.2985±0.0005 WAS .299±0.0005. ADDED NOTE: ALL BORES CONCENTRIC W/IN 0.001 TO -19 TEE DIMS	REB	
1-4	H		10/04/96	0.505±0.005 WAS 0.495±0.005. -18 PIN WAS 316 STAINLESS NOTES 1 & 2 WERE PER AC43.13-1A. REMOVED OBSOLETE -14, -15, -16, -17 PARTS. WAS 5 SHEETS.	REB	
1-4	J		07/13/98	0.500±0.005 WAS 0.505±0.005. REMOVED -1 EJECTOR DIM 1.5. -11 TUBE DIM 2.0 WAS 1.9. -19 DIM .590(REF) WAS .590(TYP)	REB	
1-4	K		03/16/00	ADDED NOTE A, ADDED 'AFTER ANODIZING' TO NOTE A. SHEET 2 'WELDED ASSY' WAS VIEW C, OF WELD ONLY. MS20818-6D WAS AN818-6D. SHEETS 00.50±0.05/-0.00 WAS ±.05. -19 TEE 00.300±0.0005/-0.0000 WAS ±0.0005. -18 PIN 00.2985±0.0000/-0.0005 WAS±0.0005	MR	LS
1-4	L		03/30/05	SH4 DIA. 0.495 ON 'TEE' LEG WAS 0.500, 0.298±0.000/-0.002 WAS0.2985±0.000/-0.0005. SH3 -11 TUBE WAS FLARED BEFORE WELDED ASSEMBLY. SH2 ADDED P/N I.D. LABEL, AIRFLOW INDICATOR W/ ALT. LASER ENGRAVE. VIEW A 0.025±0.005 WAS 0.025(±0.010)	REB	LS
1,2,4	M		12/22/06	SH. 2: EXPANDED DETAIL A-18/-19 ASSY. FOR REFERENCE EXPECTED DIMS. SH. 4: 0.2985+/-0.0005 WAS 0.298±0/-0.002. 1/4-28UNF-1A, WAS 1/4-28. DRILL 0.213 TAP 1/4-28UNF-1B WAS DRILL/TAP 1/4-28. ADDED NOTES A, A, A SHEETS 1 & 4		

1	AN315-4	NUT
1	MS20818-6D	NUT
1	MS20819-6D	SLEEVE
1	-19	TEE
1	-18	PIN
1	-12	TUBE 2 X .065
1	-11	TUBE 3/8 X .035
-1		
ASSY	PART NUMBER	DESCRIPTION
QTY.	Paravion® Inc. ✓Technology	TITLE EJECTOR ASSY.
		DRAWING NO. S-9000EC
	DIMENSIONS IN INCHES	DRAWN BY TMN
	TOLERANCES EXCEPT WHERE NOTED:	APRVD BY REB
	.X = ± .1 .XX = ± .05 .XXX = ± .010	CHK'D BY LS
		DATE 10/21/91
		REV M
		ECO
	DO NOT SCALE DRAWING	SHEET 1 OF 4
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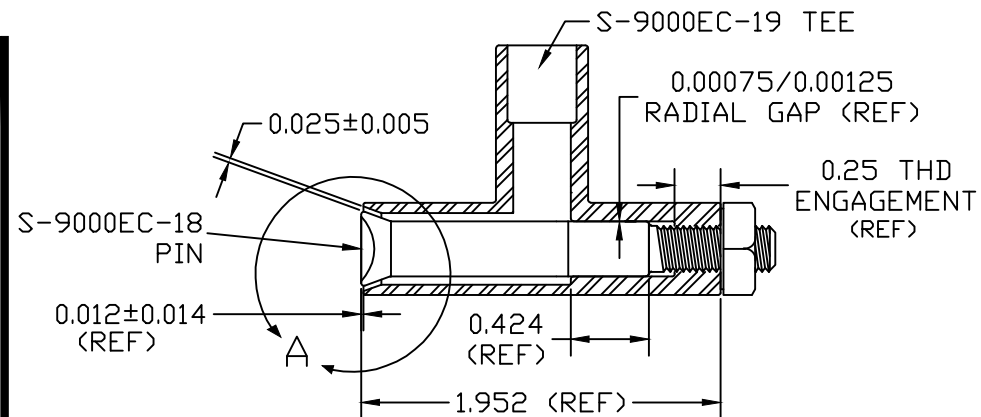
BREAK ALL SHARP EDGES

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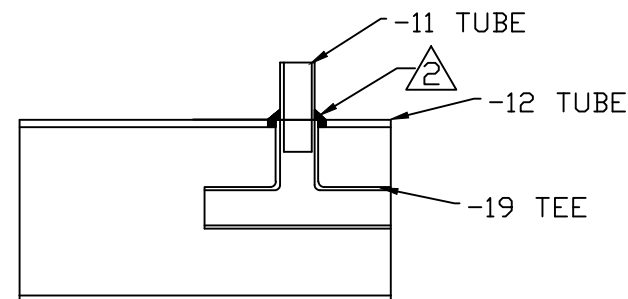
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ANGLES = ± 1°



VIEW A




5 WELDED ASSEMBLY

-1 EJECTOR ASSEMBLY

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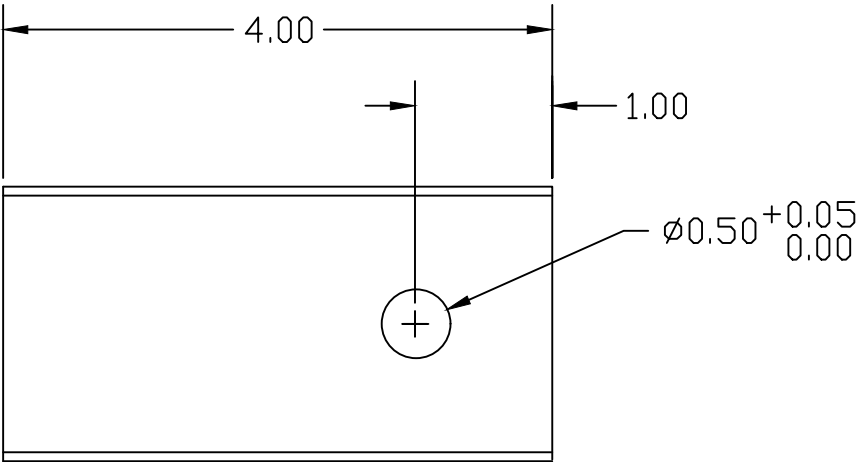
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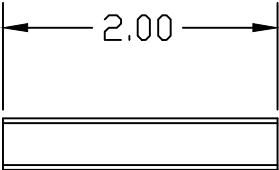
Paravion® Inc.  Technology	TITLE EJECTOR ASSY.				DRAWING NO. S-9000EC	
	DIMENSIONS IN INCHES					
	TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
	DO NOT SCALE DRAWING				SHEET 2 OF 4	
DRAWN BY TMN		APRVD. BY REB		CHK'D BY REB		DATE 10/21/91
						REV M
						ECO
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MATERIAL: 6061-T6 QQ-A-200/8, WW-T-700/6
STOCK: 2" X 0.065" WALL
SURFACE FINISH $\sqrt{125}$

MATERIAL: 5052-0 WW-T-700/4
STOCK: 3/8" X 0.035" WALL
SURFACE FINISH $\sqrt{125}$



-12 TUBE



-11 TUBE

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PROTO

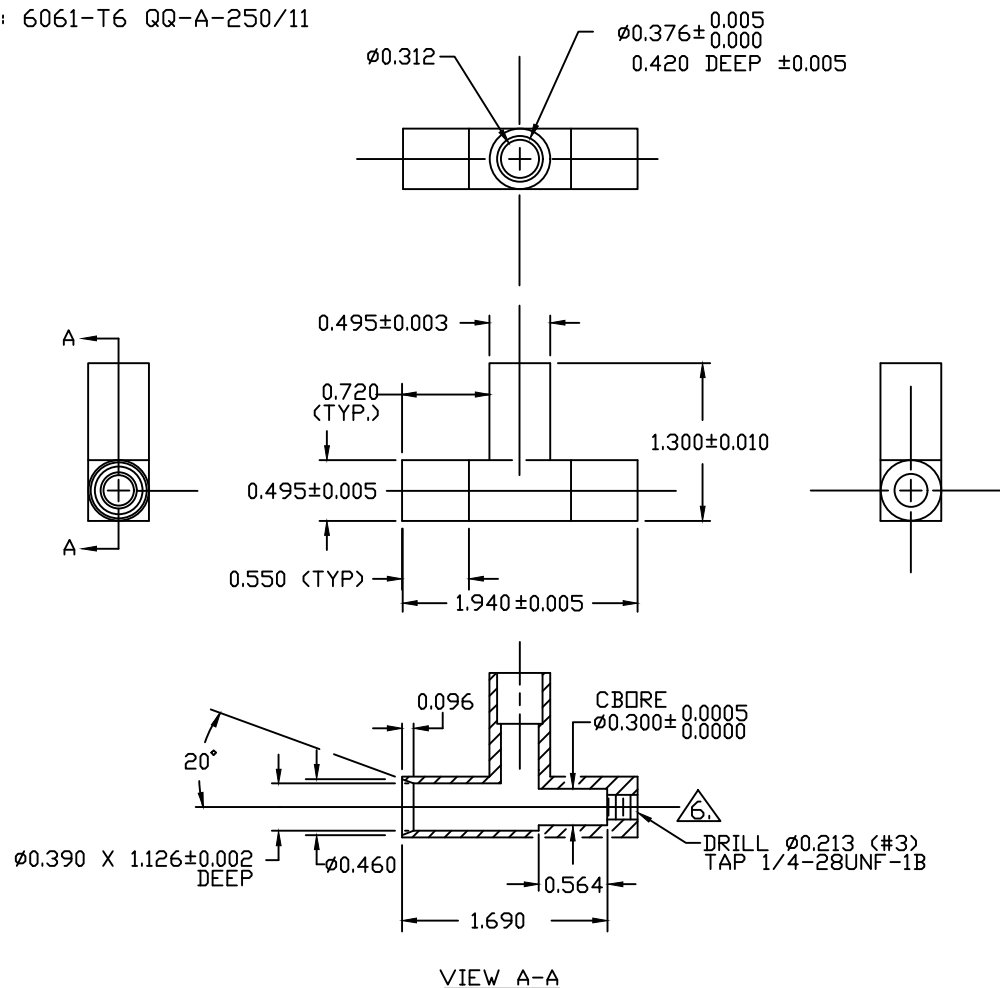
N/C

<div>Paravion® Technology</div> Inc.	TITLE			DRAWING NO.		
	EJECTOR ASSY.			S-9000EC		
DIMENSIONS IN INCHES						
TOLERANCES EXCEPT WHERE NOTED:						
DRAWN BY		APRVD BY	CHK'D BY	DATE	REV	ECO
NLH		REB	REB	09/09/85	M	
ECO				DO NOT SCALE DRAWING		
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				3 OF 4		

- △ BORES & THREAD MUST BE CONCENTRIC WITHIN 0.001
 △ CYLINDRICAL SHAFT & THREAD MUST BE CONCENTRIC WITHIN 0.001

-19 TEE

MATERIAL: 6061-T6 QQ-A-250/11

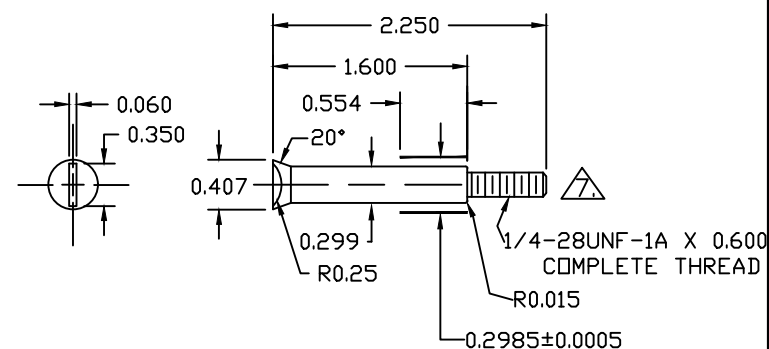


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-18 PIN

MATERIAL: 300 SERIES STAINLESS STEEL
 ALT: 400 SERIES STAINLESS STEEL



Paravion® Inc.
 Technology

TITLE
 EJECTOR ASSY.

DRAWING NO.
 S-9000EC

DIMENSIONS IN INCHES
 TOLERANCES EXCEPT
 WHERE NOTED:

.X = ± .1
 .XX = ± .05
 .XXX = ± .010

ANGLES = ± 1°

DRAWN BY	APRVD BY	CHK'D BY	DATE	REV	ECO
TMN	REB	LS	01/20/92	M	

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SHEET

4 OF 4

PROTO

N/C